








Work Order ID 65487

January 18, 2011 3:12:49 PM




Page 1

Item ID: D3481-043 Accept  Setup Start 
Revision ID: Stop 
Item Name: Bracket & Clamp Assembly *S*
Start Date: 1/18/11 Start Qty: 2.00  Cust Item ID:
Required Date: 1/18/11 Req'd Qty: 2.00  Customer:
Reference:


Approvals: Process Plan: *CL* Date: *11/01/18* Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3481	Rev B

100	Small Fab	0.00							
	Small Fab	0.00							
Small Fab	Memo								
Small Fab	1-Assemble as per Dwg D3481								
	2-Spot Weld as per Dwg D3481								

= 7 m. 11/01/31

110	QC11- Inspect spot weld per QSI004	0.00							
	QC	0.00							
Quality Control	Memo								

SB 11/02/01 *(5)*

120	QC5- Inspect part completeness to step on W/O	0.00							
	QC	0.00							
Quality Control	Memo								

SB 11/02/01 *(5)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Work Order ID 65487



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Page 2

Item ID: D3481-043 Accept  Setup Start 
Revision ID: Stop 
Item Name: Bracket & Clamp Assembly
Start Date: 1/18/11 Start Qty: 2.00  Cust Item ID:
Required Date: 1/18/11 Req'd Qty: 2.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Packaging	Identify as per dwg & Stock Location: <u>GA</u> Memo 65463	0.00				(S)			
140  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00		SB 1102101					11/02/02 df 11-02-1 (E)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 65487

Parent Item: D3481-043

Parent Item Name: Bracket & Clamp Assembly





Start Date: 1/18/11

Required Date: 1/18/11

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 11.01.18 as per dwg rev.B DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3481-3  Angle Bracket		Manufactured	No			100	Each	0.0000	1	2	5	SB 11/01/27	(S)
QS200-52S  CLAMP		Purchased	No			100	Each	10.0000	2	4		SB 11/01/27	(S)
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						ST450	10						
						105603	10						
										10			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

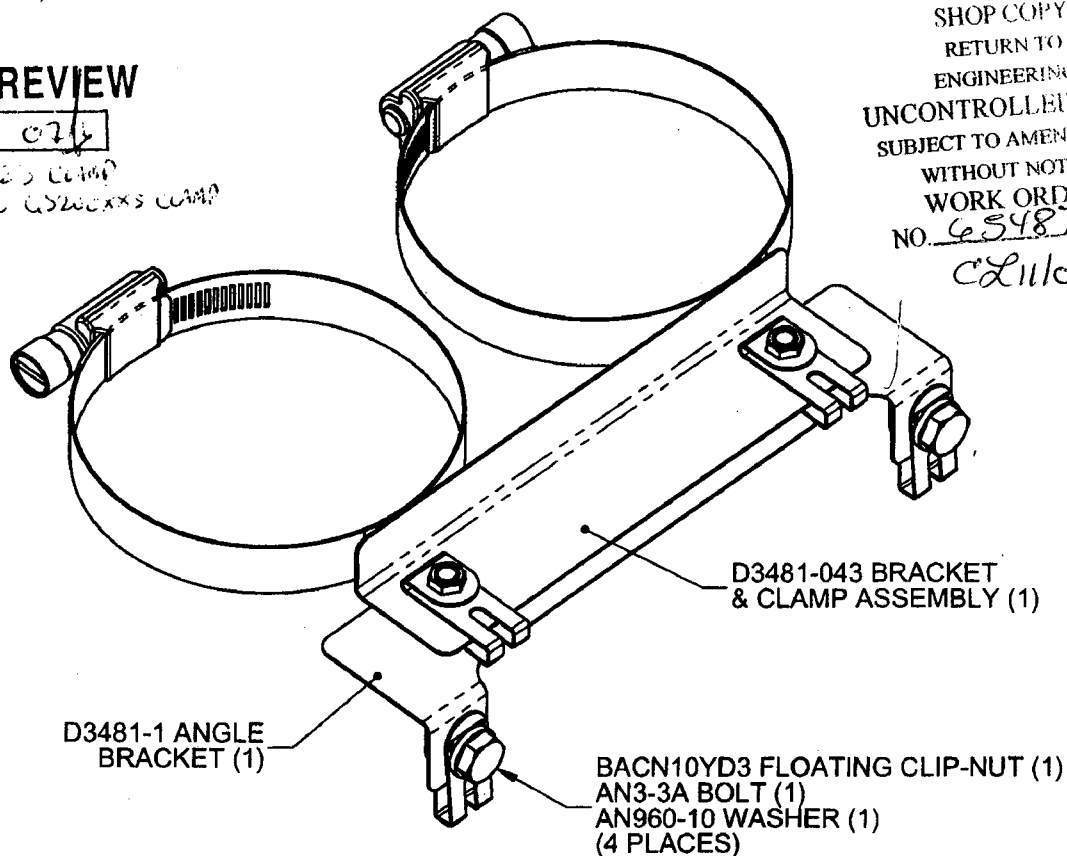
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3481	REV. A SHEET 1 OF 4
DATE 06.01.23		TITLE SHUT-OFF VALVE BRACKET	SCALE 2:3
A	06.01.23	NEW ISSUE	

06.04.03
UNDER REVIEW

07.09.07

Q520000 CLAMP
CHANGED TO Q520000S CLAMP

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WORK ORDER
NO. *65487*
C. L. 10/18



D3481-041 SHUT-OFF VALVE BRACKET

- 1) IDENTIFY WITH DART P/N D3481-041 USING FINE POINT PERMANENT INK MARKER

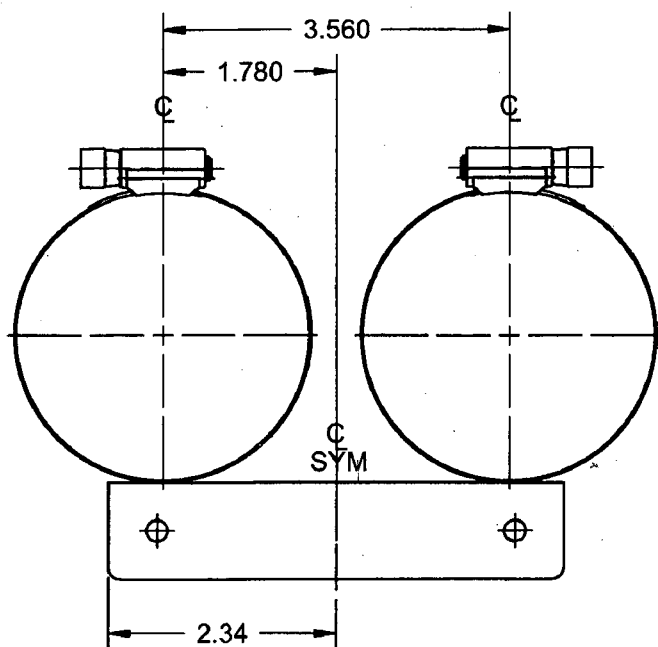
QTY -041	P/N	DESCRIPTION
X	D3481-041	SHUT-OFF VALVE BRACKET
1	D3481-043	BRACKET & CLAMP ASSEMBLY
1	D3481-1	ANGLE BRACKET
4	AN3-3A	BOLT
4	AN960-10	WASHER
4	BACN10YD3	FLOATING CLIP-NUT

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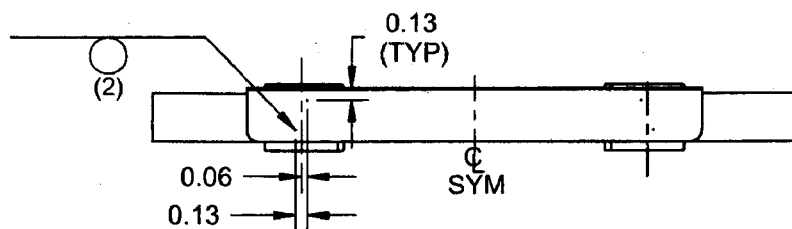
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3481	REV: A SHEET 2 OF 4
DATE 06.01.23		TITLE SHUT-OFF VALVE BRACKET	SCALE 1:2

*06.09.03*

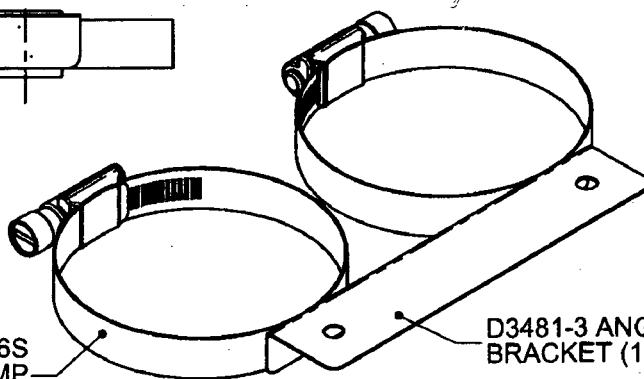
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NO. 65487

UNDER REVIEW*07.09.03*

QS20056S CLAMP
CHANGED TO QS200XXS CLAMP



QS20056S
AERO-SEAL CLAMP
(2 PLACES)



D3481-3 ANGLE
BRACKET (1)

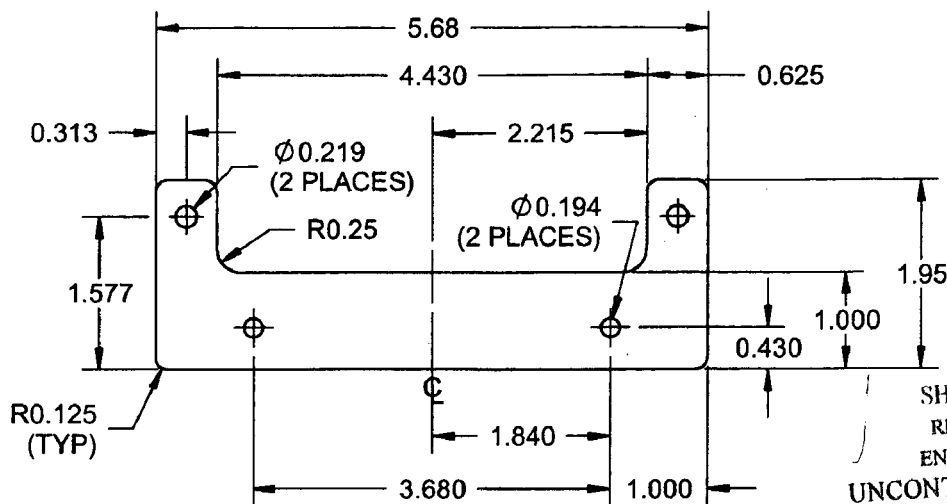
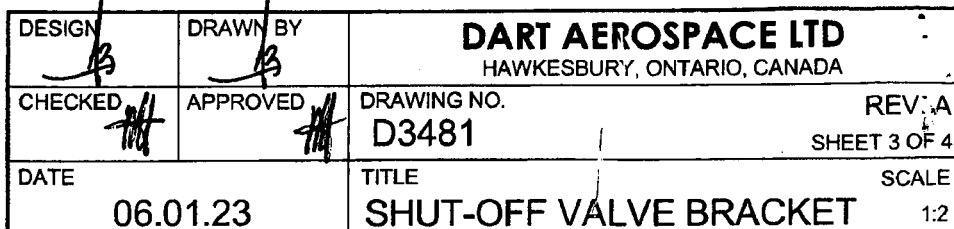
D3481-043 BRACKET & CLAMP ASSEMBLY**NOTES:**

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) ASSEMBLY IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3481-043	BRACKET & CLAMP ASSEMBLY
1	D3481-3	ANGLE BRACKET
2	QS20056S	AERO-SEAL CLAMP

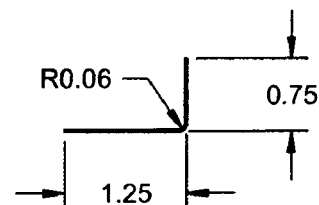
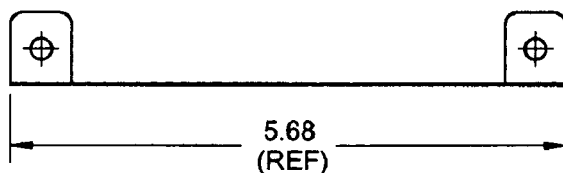
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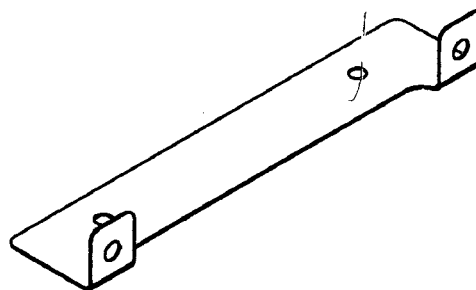


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NO. 65987

D3481-1F FLAT PATTERN



D3481-1 ANGLE BRACKET



UNDER REVIEW

07.09.07

Q5200705 CAMP
CHANGED TO Q5200705 CAMP

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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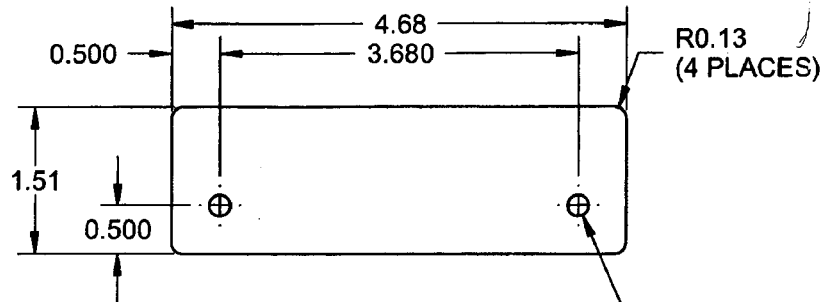
DESIGN #B	DRAWN BY #B	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #H	APPROVED #H	DRAWING NO. D3481	REV. A SHEET 4 OF 4
DATE 06.01.23		TITLE SHUT-OFF VALVE BRACKET	SCALE 1:2

UNDER REVIEW

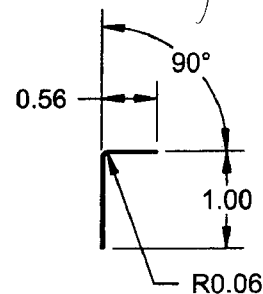
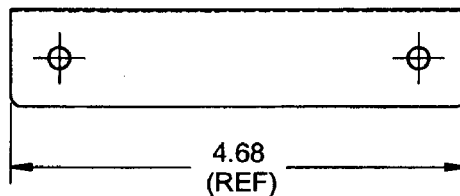
07.09.07

QS200705 COMP
CHANGED TO QS200705 COMP

06.04.03

**D3481-3F FLAT PATTERN**

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WORK ORDER
NO. 65487

**D3481-3 ANGLE BRACKET****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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SPOT WELD TEST RECORD

AMS-W-6858A

CLASS 'C'

TEST NO#: 90

EMPLOYEE: Marc Anthony

PART NUMBER: D 3481-043

JOB NUMBER: B 65487

MATERIAL TYPE: 304L

MATERIAL THICKNESS: .018

GROUP SPECIFICATION



Group 1: Aluminum & magnesium



Group 2: Iron; nickel; cobalt



Group 3: Titanium SS

TEST RESULTS

	PASS	FAIL
VISUAL:	[<input checked="" type="checkbox"/>]	[<input type="checkbox"/>]
PENETRATION:	[<input checked="" type="checkbox"/>]	[<input type="checkbox"/>]
PULL STRENGTH:	[<input checked="" type="checkbox"/>]	[<input type="checkbox"/>]

PSI Reading: _____

Qualified in accordance with standard AMS-W-6858A and QSI 004 (ref: 4.3)

DATE OF TEST COUPON: 11/21/31

QUALIFIER: SB

SPOT WELD TEST RECORD

AMS-W-6858A

CLASS 'C'

TEST NO#: 91

EMPLOYEE: Marc Gregory

PART NUMBER: D3481-043

JOB NUMBER: 65487

MATERIAL TYPE: 304L

MATERIAL THICKNESS: .016

GROUP SPECIFICATION

- ☐ Group 1: Aluminum & magnesium
☐ Group 2: Iron; nickel; cobalt
☒ Group 3: Titanium SS

TEST RESULTS

	PASS	FAIL
VISUAL:	[<u>/</u>]	[]
PENETRATION:	[<u>/</u>]	[]
PULL STRENGTH:	[<u>/</u>]	[]

PSI Reading: _____

Qualified in accordance with standard AMS-W-6858A and QSI 004 (ref: 4.3)

DATE OF TEST COUPON: 11/01/31
QUALIFIER: SG